

Work Order ID 72934

Thursday, August 18, 2011 10:46:41 AM



Page 1

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: MP

Date: 11-08-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3319	Rev B

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3319
Dwg Rev: BB
Prog Rev: BB
2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

Quality Control

11/08/22

6

11/08/22

6

11/08/22

80

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Page 2

Item ID: D3319-1

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Revision ID:

Item Name: Wearplate

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Start Date: 8/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: B
2- Form flat on press using DT8776 block

150



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

160



Large Fab

Weld per dwg A/R Hardcoat steel Batch: _____

0.00

Large Fab

Memo

0.00

Large Fab

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod

m117964

(6)

B 8 11/08/23

(46)

X6 11-08-26 JBL/LZ

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Item ID: D3319-1

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Stop



Item Name: Wearplate

Start Date: 8/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 ulos / 29

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulos / 29



190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
320 OF
9:45

0.00

6X Ø m-11/08/30

M 117338

Work Order ID 72934

Thursday, August 18, 2011 10:46:41 AM

Page 4

Item ID: D3319-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 8/18/2011 Start Qty: 6.00

Required Date: 8/26/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 d 22 4/08/30

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: ST 497

(6x) 11-08-31

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/31
mr
11-08-31

DART AEROSPACE LTD		Work Order: 72934
Description: Wearplate		Part Number: D3319-1
Inspection Dwg: D3319	Rev: B	Page 1 of 1

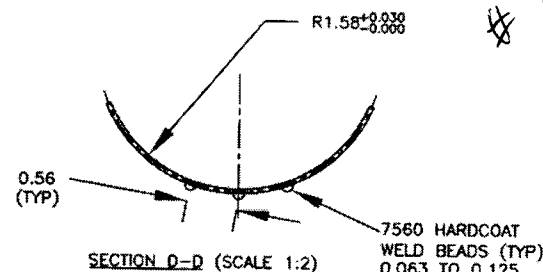
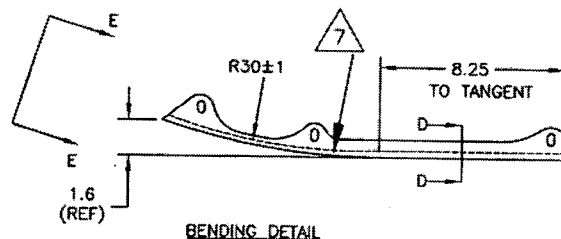
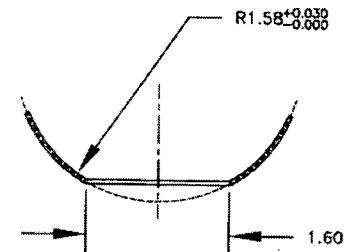
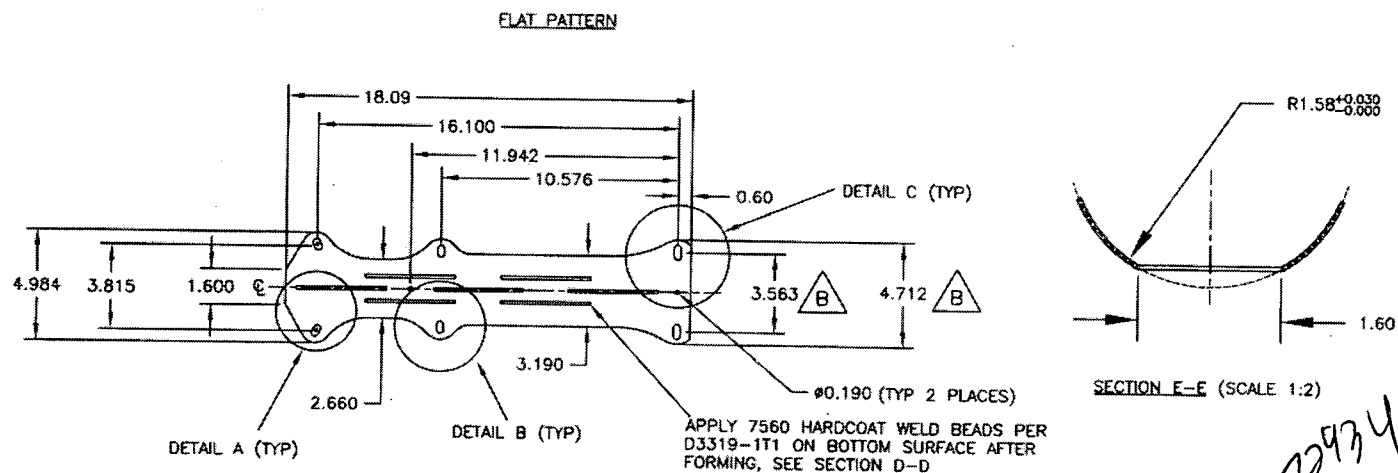
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

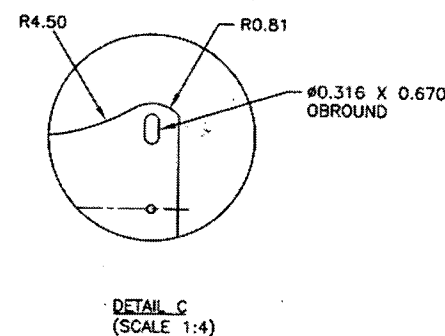
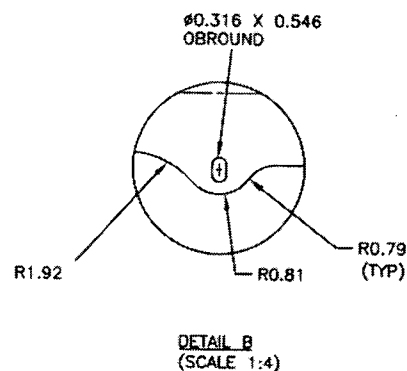
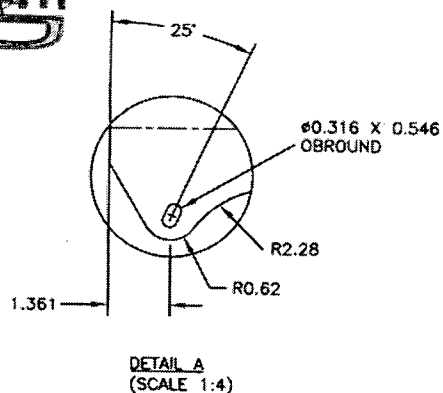
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.980	—		RA26	Verify
1.600	+/-0.010	1.605	—		"	"
2.660	+/-0.010	2.666	—		"	"
3.190	+/-0.010	3.191	—		"	"
3.563	+/-0.010	3.565	—		"	"
4.712	+/-0.010	4.710	—		"	
0.60	+/-0.030	.595	—		"	
10.576	+/-0.010	10.580	—		RA04	TAPE
11.942	+/-0.010	11.944	—		RA04	"
18.09	+/-0.030	18.100	—		RA04	TAPE
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	.315 x .544	—		RA26	Verify
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	.315 x .667	—		"	"
Ø0.190	+0.005/-0.001	.190	—		RA26	Verify

Measured by: [Signature]	Audited by: S	Prototype Approval:	N/A
Date: 11/08/22	Date: 11/08/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	[Signature]



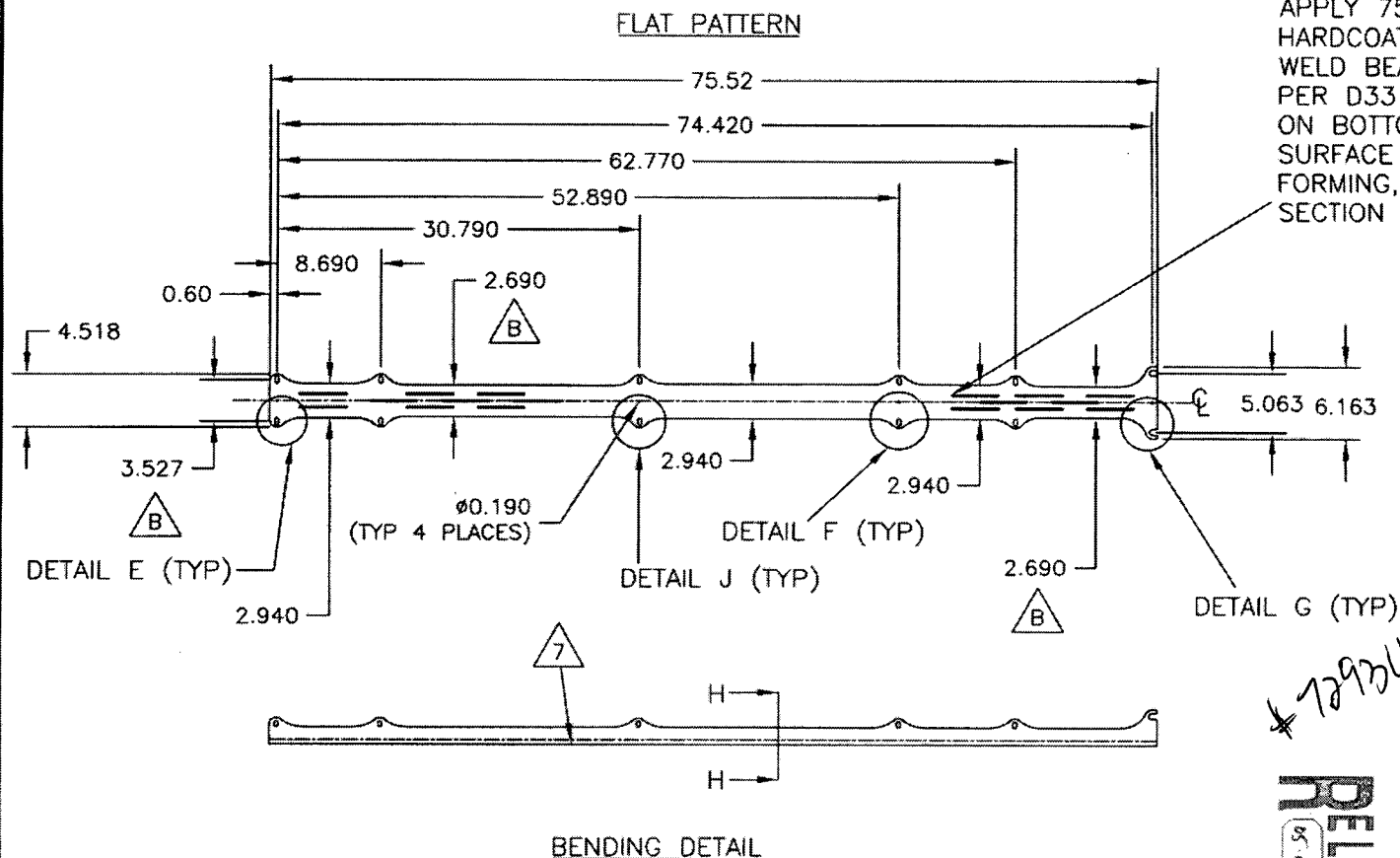
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05-09-30



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	P41	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8



APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.06.06	D3319	SHEET 2 OF 5
	WEARPLATE	SCALE
		1:15

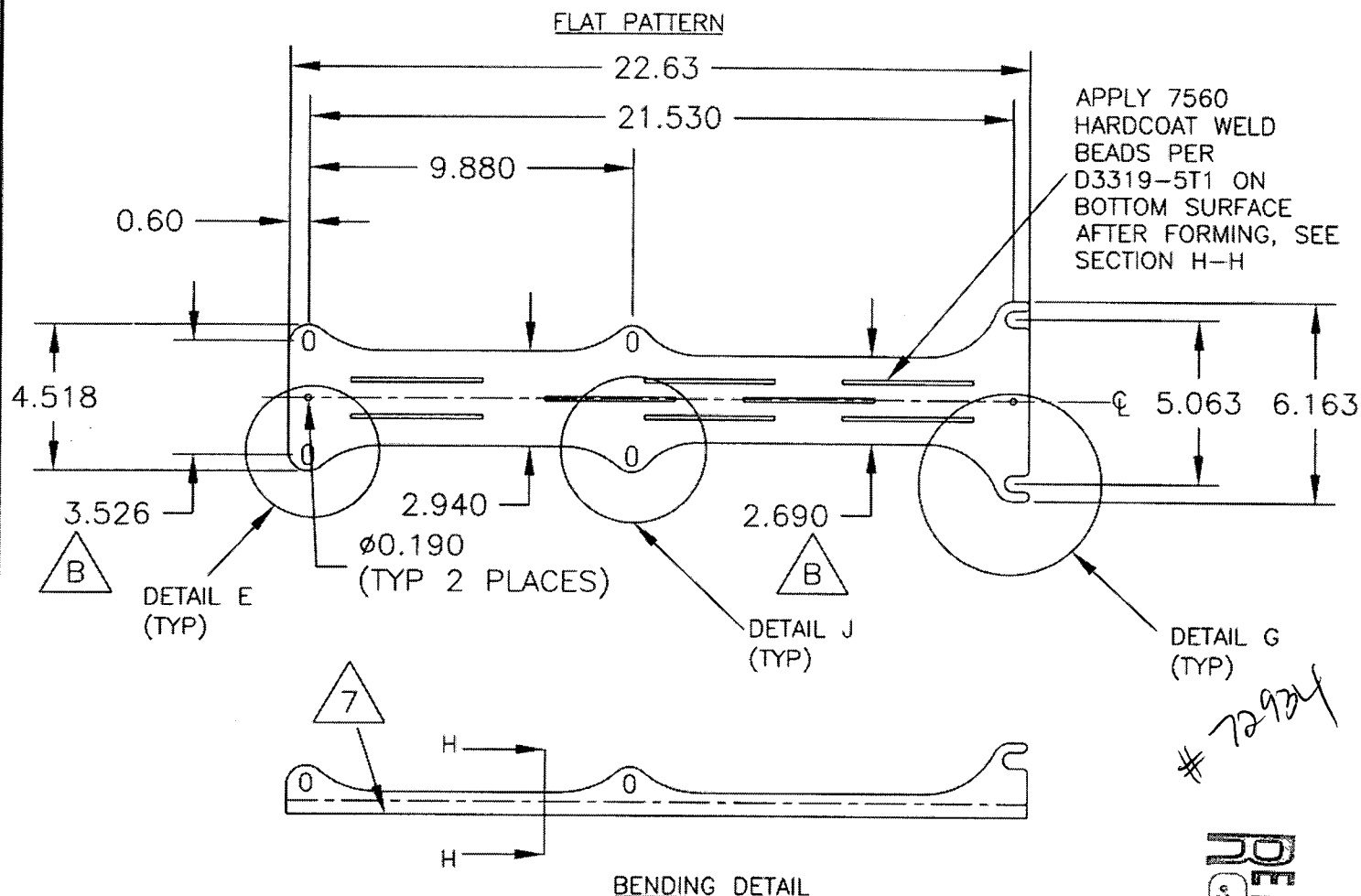
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D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN	941	DRAWN BY	941	DART AEROSPACE LTD
CHECKED	#	APPROVED	#	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
		SCALE	1:5	



D3319-5 WEARPLATE

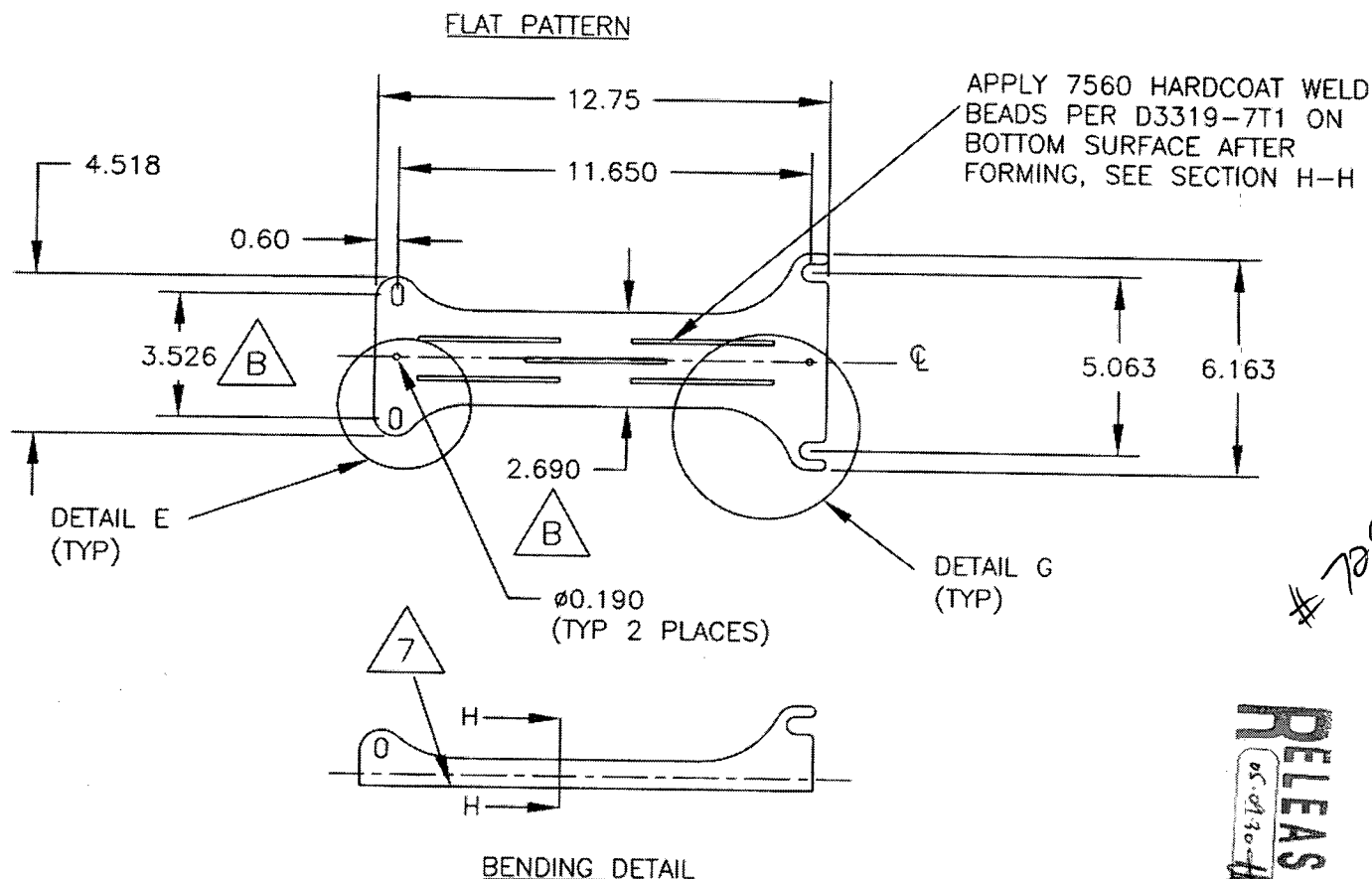
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	

72922

RELEASED
05.01.30.11

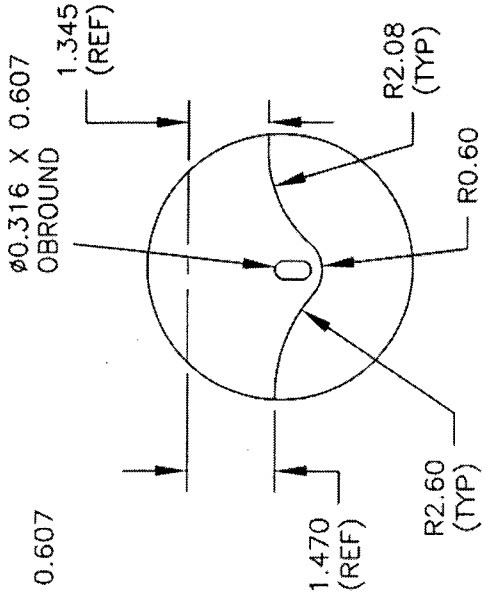


D3319-7 WEARPLATE

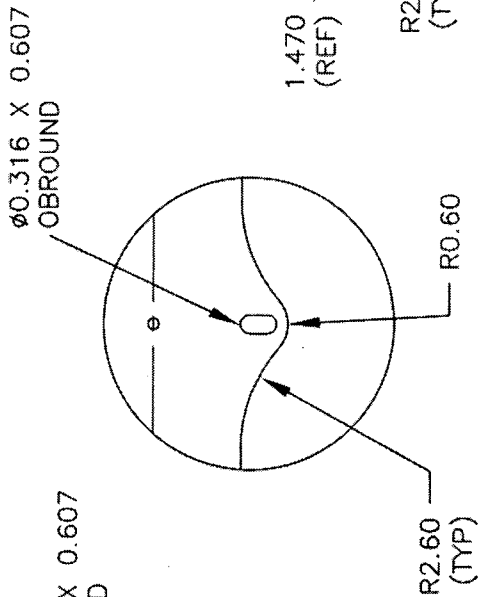
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"



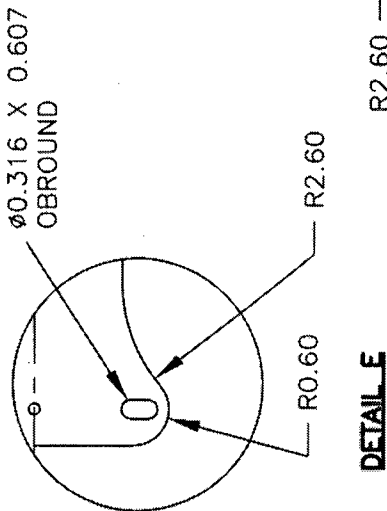
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3



DETAIL J



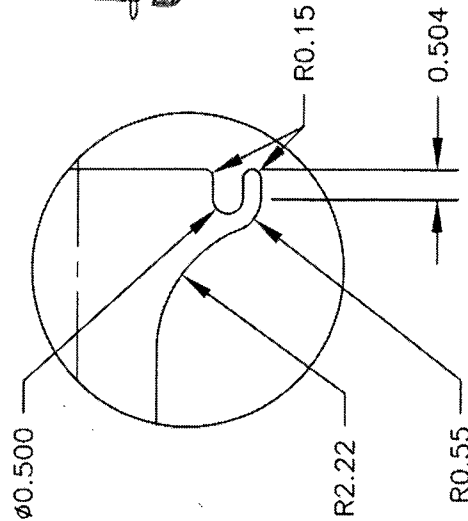
DETAIL I



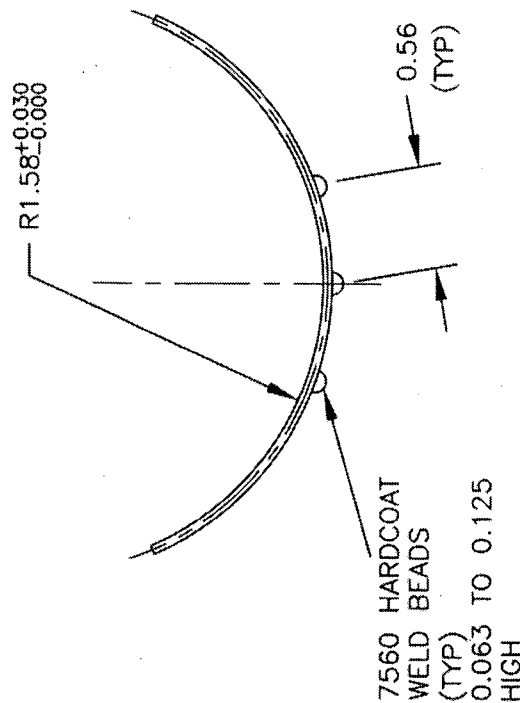
DETAIL E

Model #

RELEASED
05.09.30



DETAIL G



**SECTION H-H
(SCALE 1:1)**

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